

Work Order ID 81513

81513

Page 1

March-15-12 8:10:39 AM

Item ID: D2648-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 15/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2648

Rev D

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2648

*****CUT WITH FILE D2648-1*****

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

W 12 03 18 (20)
19

W 12 03 18 (20)
19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/1 12/3/20

19

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

8/18

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D2648-3

So 12/07/20

19

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81513

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

20

20

Reference:

Run Start *NR1*

Date:

Stop *NR2*

Date:

**Insp.
Stamp**

. 0.00

0.00

x 19

me/er

12-03-29

0.00

0.00

8/26/79

0.00

0.00

5.2/3/8

519

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Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3h10
320°F
3h40

m120222

19

JP

12/03/29

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

19

d

lll

12/3/29

200

Identify as per dwg & Stock Location:

237A

0.00

200

Packaging

Memo

0.00

Packaging

6/3/29

sf

19

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Work Order ID 81513***81513***

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Process Plan:

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Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

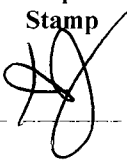
210

QC

Memo

0.00

Quality Control

12/4/2 

02-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

March-15-12 8:10:46 AM

Page 1

Work Order ID: 81513

81513

Parent Item: D2648-3

D2648-3

Parent Item Name: Wearpad

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: E02.09.18Re-format; Incorporated D2648-1KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

69.0000

0.075

1.578947

**

m 12 03 18

M1010S16GA

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

69

116791

21.4

117500

17.6

118965

30

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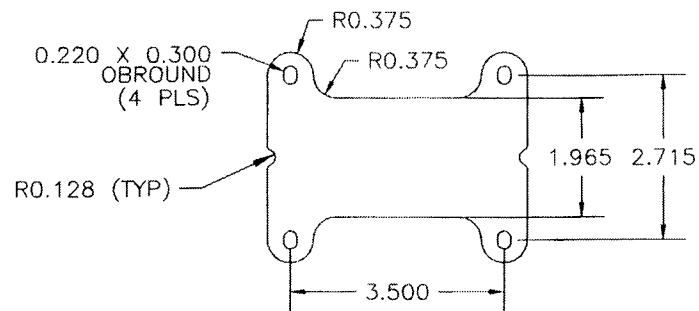
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

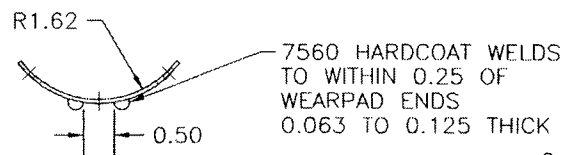
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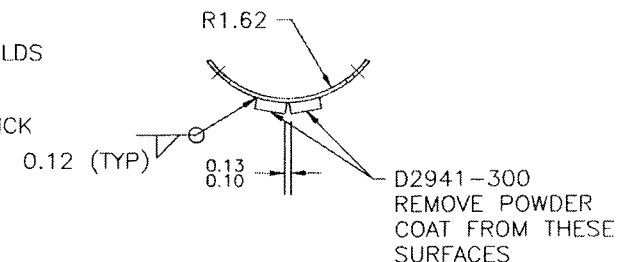
D2648-1 FLAT PATTERN



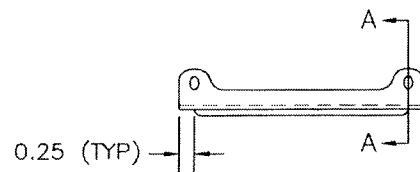
SECTION A-A



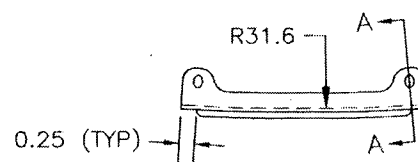
SECTION B-B



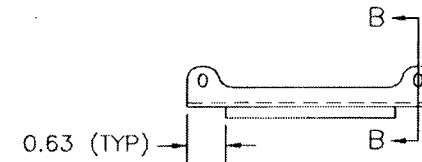
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 81513 MLJ

12/03/15

RELEASED
99.12.20 DS



D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BOLLEVILLE, WA
CHECKED	APPROVED	DRAWING NO. D2648 REV. D SHEET 1 OF 1
DATE	TITLE	SCALE
99.11.17	WEARPAD	1:2

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